

158325

Monday, March 20, 2017 11:39:03 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 3/20/2017 **Start Qty:** 4.00

4

Cust Item ID:**Required Date: 3/23/2017 Req'd Qty: 4.00**

4

Customer:

Reference: SCHEDULED

Run Start *NR1*

Approvals: Process Plan: ^{DAS}21 Date: MAR 20 2017 Tooling:

Date:

Stop *NR2*

QC: 9-89 Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3926 Rev A

100

0.00

100

0.97

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3926

Dwg Rev: A

Prog Rev: A

2-Debutt if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

0.04

QC

Memo

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Work Order ID 158325

158325

Page 2

Monday, March 20, 2017 11:39:03 AM

Item ID: D3926-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wedge

Start Date: 3/20/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/23/2017 Req'd Qty: 4.00 ***4*** Customer:

Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.08				4			DAS 38 9-89 MAR 21 2017
130 *130* Small Fab Small Fab	Memo 1- Deburr if necessary	0.00 0.52							NIA DAS 38 9-89
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.08							NIA DAS 38 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 158325

158325

Page 3

Monday, March 20, 2017 11:39:03 AM

Item ID: D3926-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wedge

Start Date: 3/20/2017 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 3/23/2017 Req'd Qty: 4.00 *4*

Customer:

Reference: SCHEDULED

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

Identify as per dwg & Stock Location. *Stosa*

0.00

150

Packaging

Memo

0.04

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.40

Quality Control

4 MAR 21 2017

DAS
6-89

17/3/23 *df*

DAS
21
9-89 MAR 22 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause			FAULT CATEGORY							
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Picklist Print

Monday, March 20, 2017 11:39:11 AM

Page 1

Work Order ID: 158325

158325

Parent Item: D3926-3

D3926-3

Parent Item Name: Wedge

Start Date: 3/20/2017

Required Date: 3/23/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	445.0170	0.2423	1.020211			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

03/17/21

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT011	13.517	
m131661	13.517	
MAT018	431.5	
m136290	31.5	
m136453	400	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date	☐	Manufacturing Process	☐								
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DART AEROSPACE LTD		Work Order: 158325
Description: Wedge		Part Number: D3926-3
Inspection Dwg: D3926	Rev: A	Page 1 of 1

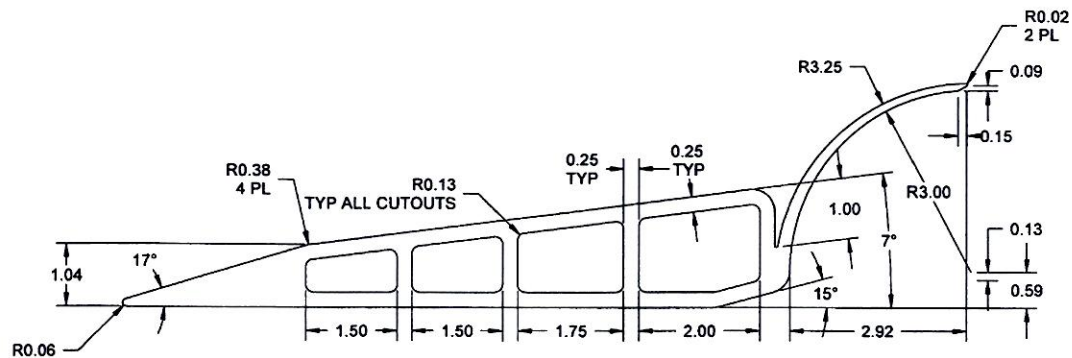
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

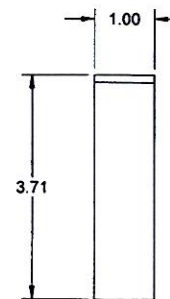
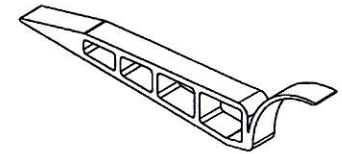
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.02	+/-0.030	3.02	1		Viper-02	
1.50	+/-0.030	1.516	1		Tap	
1.50	+/-0.030	1.518	1			
1.75	+/-0.030	1.759	1			
2.00	+/-0.030	2.016	1			
1.02	+/-0.030	1.02	1			
0.25	+/-0.030	0.262	1			
0.25	+/-0.030	0.259	1			
3.24	+/-0.030	3.236	1			
1.00	+/-0.030	0.998	1			
10.77	+/-0.030	10.77	1			

Measured by: <u> a </u>	Audited by: <u> DAS 38 </u>	Prototype Approval: N/A
Date: 17/03/21	Date: MAR 21 2017	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.17	New Issue	KJ	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158325 *MLJ*
1703-21



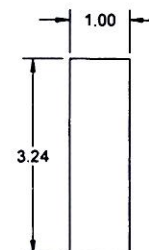
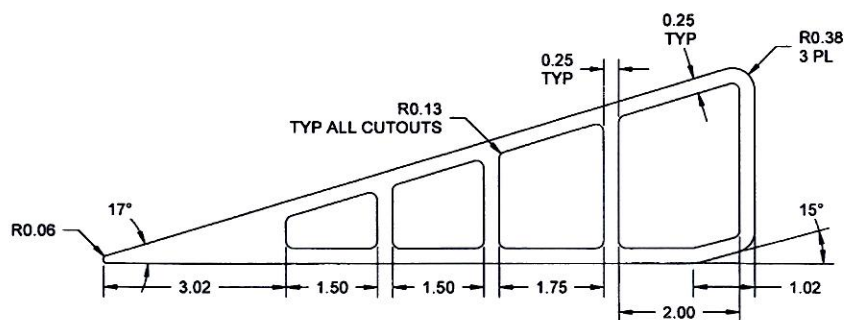
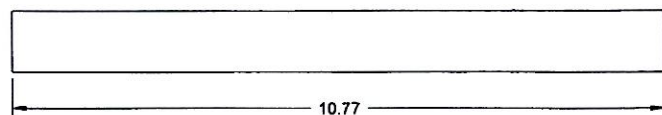
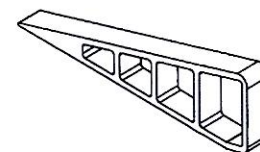
D3926-1 WEDGE

RELEASED
9/6/11

NOTES:

- 1) MATERIAL: 1.00" UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF DART SPEC MUHMBW10
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3926-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

A NEW ISSUE		09.07.23	
REV.	DESCRIPTION		BY DATE
DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D3926 TITLE WEDGE	REV. A
DRAWN			SHEET 1 OF 2
CHECKED			SCALE
MFG. APPR.			NTS
APPROVED			
DE APPR.			
DATE			09.07.23



D3926-3 WEDGE

RELEASED
9/6/17

NOTES:

- 1) MATERIAL: 1.00" UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF DART SPEC MUHMBW10
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3926-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AJS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>FE</i>	D3926	SHEET 2 OF 2
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	WEDGE	NTS
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